

SPLIT-1

Work Order ID 68799-1

Thursday, April 21, 2011 7:28:44 AM



Item ID: D2893-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.75 Support

Start Date: 4/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

*[Signature]*

Date: 4/21/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2893	Rev B

100	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA081 Tumble & Deburr								

20 11-5-12  
BA 11/05/13

1 0

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

~~20 11-5-12~~  
BA 11/05/13

1 0

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

8 11/05/13

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

Mask Bore for Priming START TIME: 3:00  
OVEN TEMPERATURE 3:30 FINISH

IX M-L 11/05/13

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

SAD 11-05-13 (2)

150

SprayPaint

0.00



SprayPaint

Spray Painting

Memo

0.00

Prime inside surface as per Dwg D2893 and QSI 005 4.3

ST 11-05-14 (21)

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*5/11/2011*

*(4)*

*X take  
away*

*BT 11-05-16 (x1)*

*11/5/16*

*11-05-14*



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 7:29:14 AM

Page 1

Work Order ID: 68799

Parent Item: D2893-1

Parent Item Name: 2.75 Support




Start Date: 4/21/2011

Required Date: 4/27/2011

Start Qty: 20.00

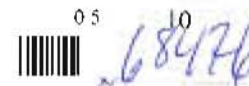
Required Qty: 20.00

Comments: IPP: C 02.11.26 Reformat: Added P/O KJ  
IPP D 06.04.19 removed alodine EC  
IPP Rev:E Added priming as per Rev B 07-04-30 JLM  
IPP F 08.03.19 Re-format EC verified by: DD  
IPP Rev:G 08-05-15 add QC14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078 		Manufactured	No			100	Each	0.0000	0.5	10			
D2893-1 TURNING DETAIL													

B 68476

1.000



68476

BA 11/05/13

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	08799
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995			Vern	GA-01
AB	0.440	0.460		0.441			"	"
AC	0.125	0.160		0.128			"	"
AD	0.040	0.060		0.050			H-G	31006
AE	0.188	0.193		0.190			Vern	GA-01
AF	0.125	0.160		0.138			"	"
AG	0.140	0.160		0.151			Mic	118-120
AH	1.360	1.400		1.378			H-G	31006
AI	0.040	0.060		0.051			"	"
AJ	1.190	1.230		1.220			"	"
AK	0.010	0.020		0.010			"	"
AL	0.053	0.073		0.063			R-G	ref.
AM	0.240	0.260		0.250			"	"
AN	2.518	2.538		2.530			Vern	GA-01
AO	84.39	90.39		87.39			R-G	ref.
AP	0.261	0.266		0.264			Vern	GA-01
AQ	0.053	0.073		0.063			R-G	ref.
AR								
AS								
AT								
Accept/Reject								

Measured by: B.A.	Date: 11/05/13
Audited by: S	Date: 11/05/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

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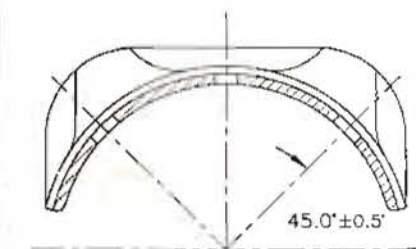
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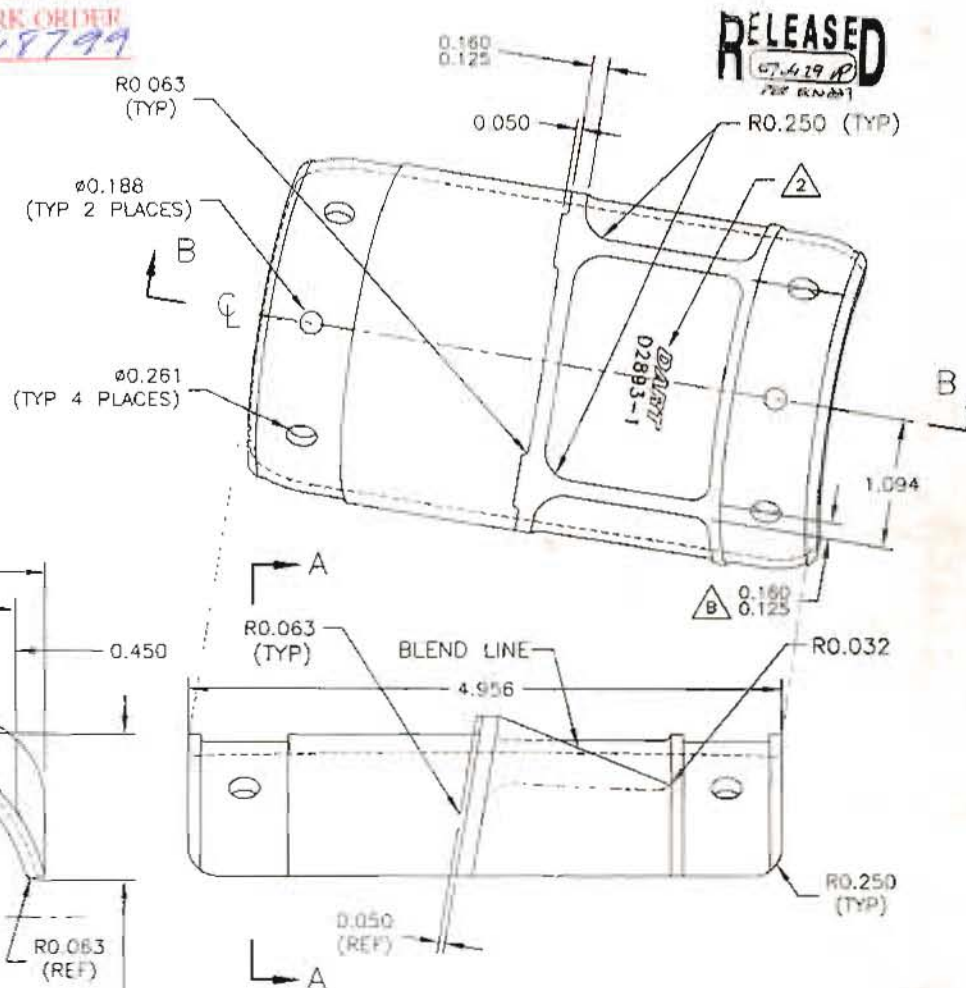
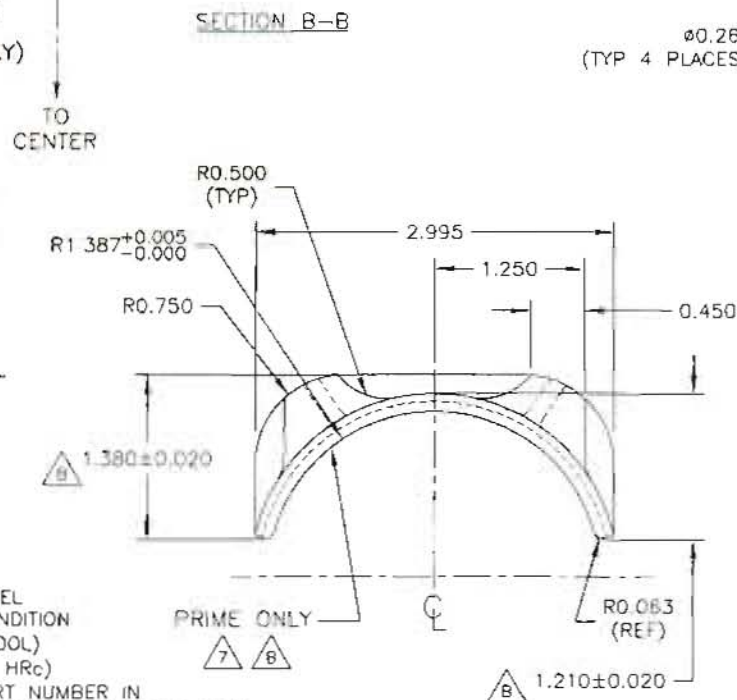
NOTE: Date & initial all entries

PL 11-04-21



WITH THE NEW  
WORKS COLLECTION



SECTION A-A  
TOOLING HOLE DETAIL



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- PRIME ONLY  
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN  
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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DART AEROSPACE LTD

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN	90	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. WARRINGTON, CHESHIRE, ENGLAND
CHECKED	PH	APPROVED	DRAWING NO D2593
DATE	07.03.16	#2.750 SUPPORT	



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